

Ship ASD

Work Order ID 70922



Friday, June 17, 2011 11:55:10 AM

Item ID: D350-607-045AGB

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener) - Gloss Black

Start Date: 6/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-045A CHG001

*8 u/a 6/22*

*After CL 11-6-22*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

PULL FROM STOCK:  
1 X D350-607-045 B55590

*EP 4/06/20 ①*

111

0.00



Small Fab

Memo

0.00

Small Fab

DISASSEMBLE ENTIRE BASKET  
REMOVE ALL PARTS, PUT PARTS ASIDE TO RE-ASSEMBLE AFTER  
BASKET IS RE-PAINTED  
RETURN D2332-041B55341 TO STOCK

*EP 4/06/20 ①*

# Work Order ID 70922

Friday, June 17, 2011 11:55:10 AM



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Item ID: D350-607-045AGB

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Item Name: Heli-Utility-Basket (Automatic Lid Opener) - Gloss Black

Stop



Start Date: 6/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

112

0.00



Large Fab

Memo

0.00

Large Fab

GRIND FLUSH D2327-3 BUSHING  
TRIM STEEL MESH LOCALLY A/R  
TRANSFER DRILL 2 X 0.194 HOLES THRU BASKET LID SQUARE TUBE  
AND 2 X 0.194 HOLES THRU BASKET BASE SQUARE TUBE PER D350-607-1 DETAIL M

PC 11.06.20

113

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subtotal

114

0.00



Powdercoat

Memo

0.00

Powder Coating

RE-POWDER COAT GLOSSY BLACK  
PROTECH PS111N9 B  
PER QSI005  
RE- WING WALK IF NECESSARY

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
PN	D350-607-045	CHG	CHG003		
DESC	Heli-Utility-Basket	SIC	SH94 14		
LOT	B55590	SIC	SR00213NY		
MODEL	AS350/355	SIC			
MADE IN CANADA				D27294	

Start Time: 8:30  
Temp: 400 °F  
Finish Time: 9:00

1X of M-1

11/06/21

**Work Order ID 70922**

Friday, June 17, 2011 11:55:10 AM



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Item ID: D350-607-045AGB

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Item Name: Heli-Utility-Basket (Automatic Lid Opener) - Gloss Black

Start Date: 6/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*ESU/06/21*

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

RE-ASSEMBLE PER DRWG D350-607-1  
TO MAKE A D350-607-045A  
USING ORIGINAL PARTS  
Assemble as per Dwg D350-607*ESU/06/21*

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*ESU/06/21*

**Work Order ID 70922**

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Friday, June 17, 2011 11:55:10 AM

Item ID: D350-607-045AGB

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener) - Gloss Black

Start Date: 6/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ENSURE ORIGINAL PKG KIT IS INCLUDED IN BOX

B70811 D350-607-241

11/16/22

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/16/22

x

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

RE-PACKAGE PER PPP  
USING NEW B/N  
Identify and pack for shipping as per PPPD350-607-045A  
Location: \_\_\_\_\_

Reo Draft

11/16/22

**Work Order ID 70922**

Friday, June 17, 2011 11:55:10 AM



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Item ID: D350-607-045AGB

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener) - Gloss Black

Start Date: 6/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/22  
ME  
11-06-22

# Picklist Print

Friday, June 17, 2011 11:55:08 AM

Page 1

Work Order ID: 70922

Parent Item: D350-607-045AGB

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener) - Gloss Black

Start Date: 6/17/2011




Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC  
as per ecn 10-545 DD 10.04.19 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-607-045  Heli-Utility-Basket, LH/RH		Manufactured	No				Each	1.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG101		1							
				55590		1							
D2258-200  Placard 200lb		Manufactured	No			110	Each	9.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST505		9							
				64284		1							
				68928		8							
D2931  Bumper		Manufactured	No			110	Each	646.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		646							
				46064		646							
D350-607-145  Automatic Lid Opener Installation		Manufactured	No			110	Each	0.0000	1	1			

B70923 (12)

*[Handwritten signature]*

*[Handwritten signature]* 6/11/06/22

*[Handwritten signature]* 6/11/06/22

*[Handwritten signature]* 6/14/06/21

# Picklist Print

Friday, June 17, 2011 11:55:08 AM

Page 2

Work Order ID: 70922



Parent Item: D350-607-045AGB



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener) - Gloss Black

Start Date: 6/17/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

110

Each

941.0000

2

2



Cherry Rivets



*Handwritten signature*  
*6/11/06/22*

Location

Loc Qty

Loc Code

ST321

808

111636

118

117505

500

117601

190

WA018

133

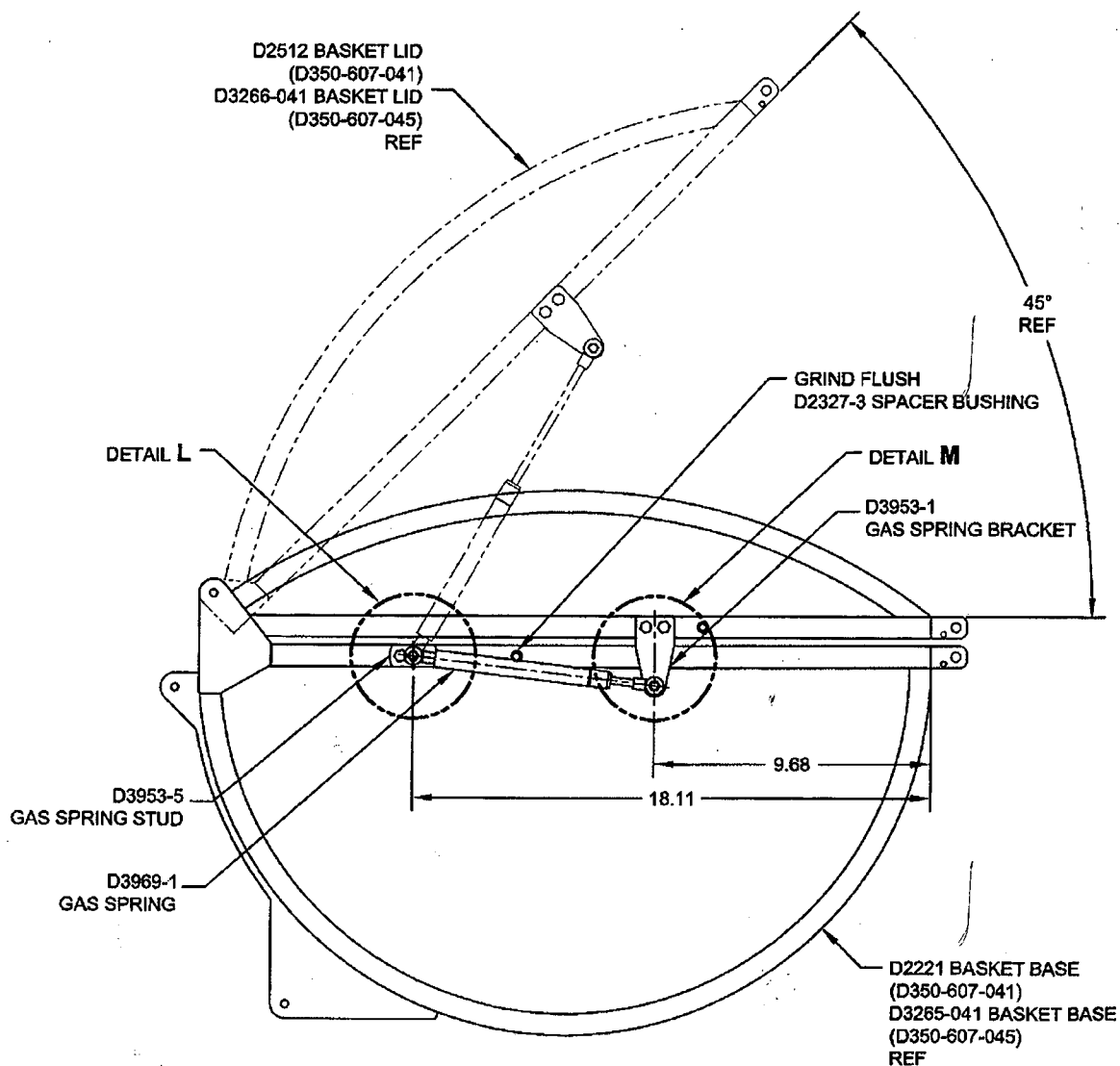
107939

133

*Handwritten '2' and lines*

*D350-607-241 B 70811*

*MF*  
*11-06-22*



**D350-607-141 AUTOMATIC LID OPENER INSTALLATION**  
(BOTH ENDS)

**D350-607-145 AUTOMATIC LID OPENER INSTALLATION**  
(1 END ONLY)

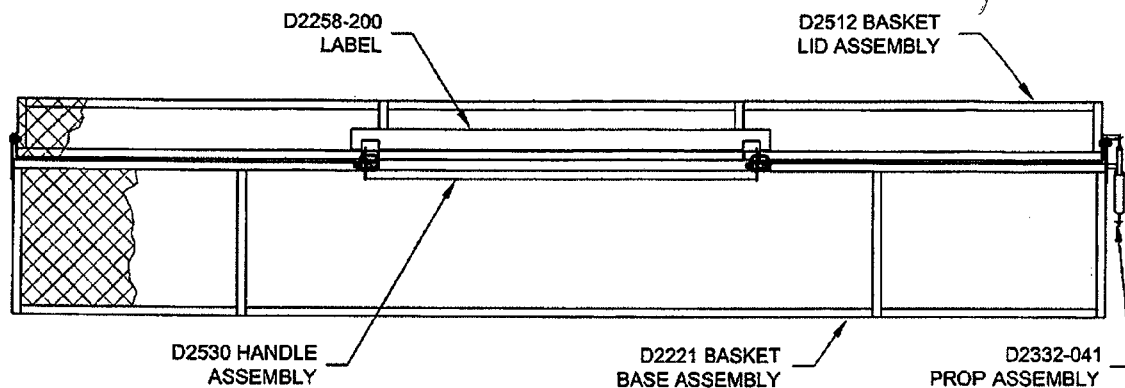
**Figure 8a – Automatic Lid Opener Installation**

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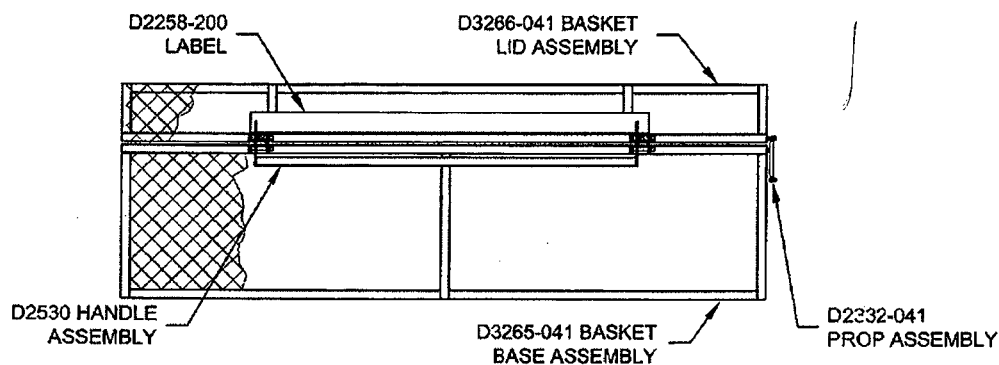
Revision: **A**

Date: 10.03.10

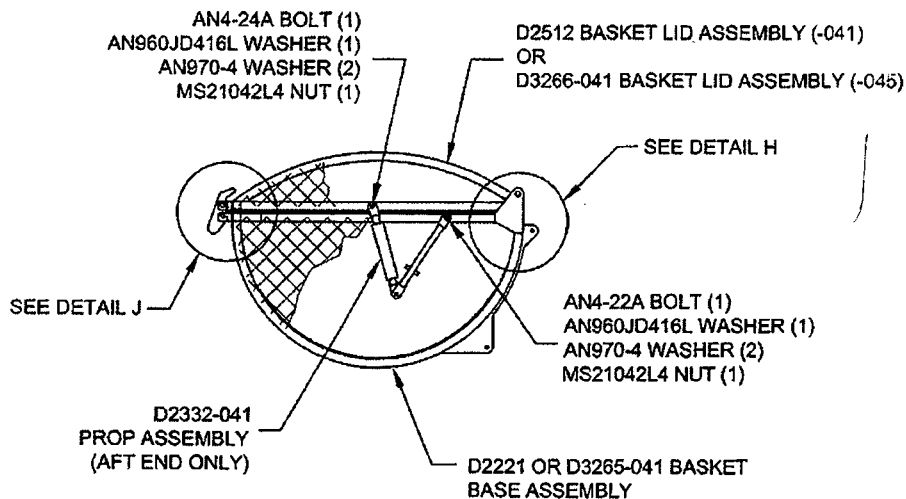




**D350-607-041 HELI-UTILITY- BASKET™**



**D350-607-045 HELI-UTILITY- BASKET™**



**VIEW C-C**  
**PROP ARM DETAIL**

**Figure 5 – Basket Replacement Parts**

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Revision: **A**  
Date: 10.03.10

- 4.2.6 Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

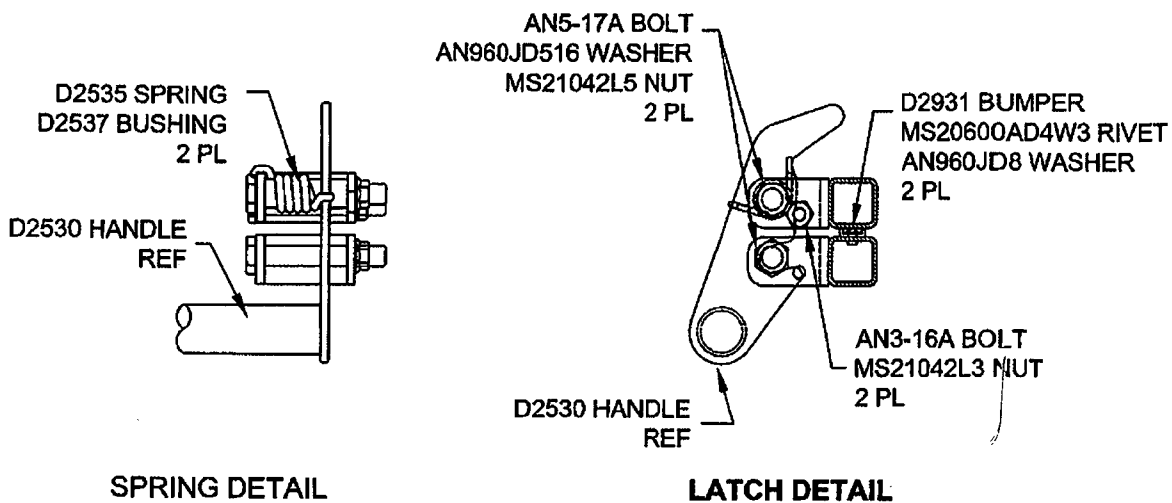
#### 4.3 D350-607-145 AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)

**NOTE:** This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

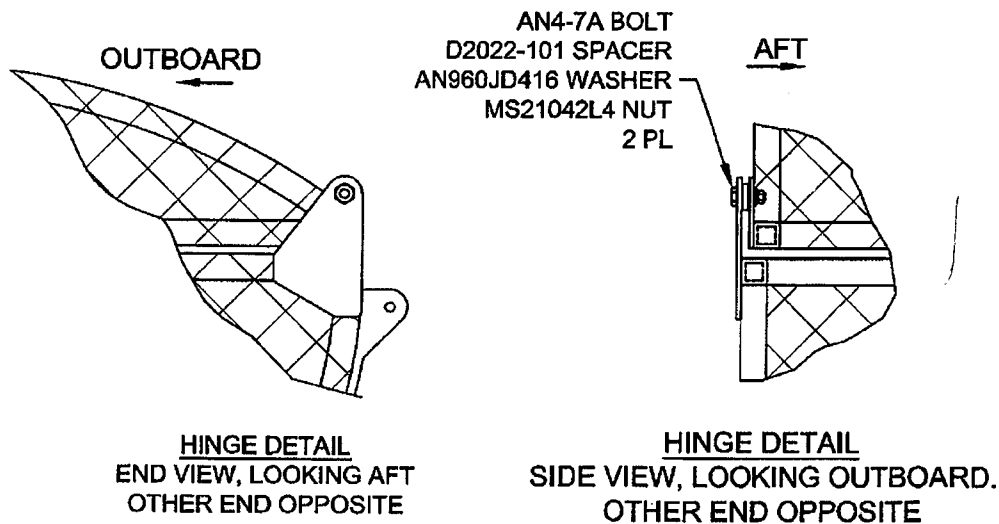
- 4.3.1 Remove the D2332-041 Prop Arm.
- 4.3.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 8a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.3.3 Locate the D3953-1 Gas Spring Bracket as shown in Figure 8a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket lid square tube structure as shown in Detail M. Install the D3953-1 Gas Spring Bracket & D3953-13 Gas Spring Spacer using 2X AN3C16A Bolt, 2X NAS1149C0332R washer & 2X MS21043-3 Nut as shown in View P-P.
- 4.3.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.3.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.3.6 Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
- NOTE:** With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.3.7. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

#### 4.4 D350-607-241 BASKET CLAMP KIT INSTALLATION

Refer to Section 3.0 of these instructions to install the D350-607-241 Basket Clamp Kit. Amend weight and balance accordingly per Section 5.0 of these instructions for each D350-607-241 Kit installed on the aircraft.



**DETAIL J:  
HANDLE WELDMENT**



**DETAIL H:  
HINGE**

**Figure 7 – Basket Replacement Parts**

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Revision: **A**  
Date: 10.03.10

# Picklist Print

Page 5

January 22, 2010 11:11:30 AM

Work Order ID: 55590

Parent Item: D350-607-045

Parent Item Name: Heli-Utility-Basket, LH/RH

Start Date: 1/22/10

Required Date: 1/29/10

Comments: IPP Rev:C as per DSI9318 06-01-24 JLM  
IPP Rev:D Ecn1068 07-12-21 DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2022-101		Manufactured	No			110	Each	447.0000	2.0000			
Spacer											10-2-10 SP	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST504	447	
45885	247	
50746	100	
52325	100	

D2258-200

Manufactured No

110 Each 8.0000 1.0000



Placard 200lb

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	8	
48350	1	
54036	7	

D2332-041

Manufactured No

110 Each 3.0000 1.0000



Lid Prop Assembly 6.69" long

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
572	3	
51969	3	

January 22, 2010 11:11:30 AM

Shop Packet Print

Page 5

## List Lots

Friday, June 17, 2011 9:58:40 AM

Page 1 of 1

Criteria : Item ID: d350-607-045 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D350-607-045 Heli-Utility-Basket, LH/RH	Main Warehouse FG101	55590	3/16/2010	1.0000		QC21	CHG003	
Total:				1.0000				

62735